

Date: Thursday, 02/04/2009 8:46:38 AM
 User: Julie Dawson

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: D206-642-512
Job Number	: 46791		
Estimate Number	: 10804		
P.O. Number	:	Part Number	: D206642512
This Issue	: 02/04/2009 S.O. No. :	Drawing Number	: R09-025/NCR09-031
Prsht Rev.	: NC	Project Number	:
First Issue	: / / Type : SKIDTUBES	Drawing Revision	:
Previous Run	: 00015	Material	:
Written By	:	Due Date	: 09/04/2009 Qty: 1 Um: Each
Checked & Approved By	: <u>JUP 09.04.01</u>		
Comment	:		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D206642512	Float Skidtube RH
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Float Skidtube RH
 Original B35202 @ CHG003

2.0	QC	QUALITY CONTROL
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Comment: QUALITY CONTROL

Upon receipt inspection. I was noticed that the 12th (from the aft) inbord bolt was un-bolted (not fully inserted), the 14th bolt f(rom the aft) inbord was missing, and the 3rd bolt (inbord) from the fwd section has a spinning insert.

No other apparent bolts were loose, and all remaining bolts were torqued to spec of 25 inch lbs per the IIN.

The rubber gasket at the aft loose bolt location was distorted. See attached photos on NCR 09-031 & R09-025.

09-04-02

3.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Disassemble the entire tube, and keep all existing hardware. Ensure to clearly identify the hardware being disassembled to maintain tracability, for re-assembly.

09-04-28 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D206-642-512

Job Number: 46791

Part Number: D206642512

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

QC

QUALITY CONTROL



Comment: QUALITY CONTROL

Evaluate, and inspect the tube. Record additional findings:

- The bolts with the least amount of s.krafter had LPS 3 leaking out
- The 2 identified inserts were loose & spinning (Most likely the bolt was r-threaded during assembly.
- The missing bolt insert was snug & not loose.
- Out a few loose inserts ^{found} upon re-snugging the inserts with the insert gun.
- Upon testing by eng. lab, it was found that the LPS 3 weakens the rubber gasket (becomes soft) and most likely penetrate under the inserts, and lubricate, causing the insert to slightly spin, and one spin, will loosen the insert completely. LPS will now be removed.

09.04.21

5.0

QC

QUALITY CONTROL



Comment: QUALITY CONTROL

W/O to be completed at later date after evaluation.

Job Completion



N/A
Job continued.
209.04.21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 21/04/2009 4:54:51 PM
User: Julie Dawson

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D206-642-512

Job Number: 46791

Part Number: D206642512

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

QC

QUALITY CONTROL



Comment: QUALITY CONTROL

Evaluate, and inspect the tube. Record additional findings:

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

-Remove all LPS 3 from inside of the tube with LPS lube cleaner.

-Replace the identified inserts.

-Wash all the existing hardware to remove the LPS Procyon, and keep for re-assembly.

- Strip & de-powder coat per Q51005 09-07-22 *XC*

Pick the following for re-assembly:

TOUCH-UP Alodine *HL* 09-04-23 *XC*

Pressure wash - *FL* 09/04/24 *1*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
09-04-27	5.1	QC.3 inspection Powder Coat/chemical conversion	YH	09-04-28	X1	[Signature]	S. [Signature]	
09-04-28	5.2	INSTALL INSERTS / QC5 inserts inspection YH 09-04-28 x10	↓	↓	↓	[Signature]	S. [Signature]	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 21/04/2009 4:54:51 PM
User: Julie Dawson

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D206-642-512

Job Number: 46791

Part Number: D206642512

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

ALS71032130

Insert



Ph →

Comment: Qty.: 78.0000 Each(s)/Unit Total : 78.0000 Each(s)

Replace as necessary:

B 10860 Qty 78

jsl

7.0

D353615

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: 1340287

jsl

8.0

D353623

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: 1344646

jsl

9.0

D353635

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: 1338905

jsl

10.0

D353639

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: 1339666

jsl

11.0

AN960C10L

washer



Comment: Qty.: 80.0000 Each(s)/Unit Total : 80.0000 Each(s)

Pick:

Qty Part Number Description Batch

As required for re-assembly:

AN960C10L

Washer 14110985 Qty 80

jsl

09-04-28 (XU)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
9/4/28	# 5.1	inspect inserts and nut places QCS Soglar/28					Soglar/28

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 21/04/2009 4:56:20 PM
 User: Julie Dawson

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: D206-642-512
Job Number	: 46791	Part Number	: D206642512
Estimate Number	: 10804	Drawing Number	: R09-025/NCR09-031
P.O. Number	:	Project Number	:
This Issue	: 21/04/2009	S.O. No.	:
Prsht Rev.	: NC	Drawing Revision	:
First Issue	: 02/04/2009	Type	: SKIDTUBES
Previous Run	: 00015	Material	:
Written By	:	Due Date	: 09/04/2009
Checked & Approved By	:	Qty:	1
Comment	:	Um:	Each

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

2- Install wearpads & gaskets as per Dwg D3274.

3- A/R Sikaflex-291 M111087
 Sikaflex expire date: 10/20

4- Inspect for foreign objects as per QSI 024

5- Install Aft Cap and seal with Sikaflex. Clean excess adhesive.

A/R Sikaflex-291 M111087
 Sikaflex expire date: 10/20

09-04-28 (46)

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09-04-29 (1)

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

- Re-package with original kit.
 Identify and stock
 Location: Rev D 9469

New P/W labels required with the new Batch #

CH6003

09-04-29 (1)

14.1 QC4 ensure original kit is needed & p/w is correct.

09-04-29 (1)

B34747 / 46791-512

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Date: Tuesday, 21/04/2009 4:56:20 PM
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Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D206-642-512

Job Number: 46791

Part Number: D206642512

Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

QC21

FINAL INSPECTION/W/O RELEASE



09/04/30 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
09-04-30

* SCRAP 1" END-CAP D2646/B33289

Then replace it with a new one D2646/B46327

9/1 09-04-28 (X1)

* SCRAP BOLT 2" AN3C-4A/M105810 Then replace it
with new ones 2" AN3C-4A/M111424

9/1 09-04-28 X1

B 4 6 7 9 1

DART

RELEASED

07.02.12

DESIGN CP	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3274	REV. D SHEET 1 OF 4
DATE 06.12.19		TITLE SKIDTUBE ASSEMBLY	SCALE NTS
A	04.03.15	NEW ISSUE	
B	04.08.09	MOVE SADDLE HOLE: 42.14 WAS 42.76	
C	05.03.16	ADD -043; NEW INSERTS	
D	06.12.19	NEW INSERTS, SS WEARSHOE + GASKET	

Qty -041	Qty -043	Part Number	Description
X		D3274-041	SKIDTUBE ASSEMBLY
	X	D3274-043	SKIDTUBE ASSEMBLY
1	1	D2600-1-240	EXTRUSION
1	1	D2646	AFT CAP
12	12	D2649	CROSS BOLT SPACER
12	37	D3275-1	CROSS BOLT SPACER
1	1	D3282-041	FLOAT WEB
1	1	D3285-1	CAP
1	1	D3413-1	RING
1	1	D3415-041	NUT PLATE
1	1	D3535-15	WEARSHOE
1	1	D3535-23	WEARSHOE
1	1	D3535-35	WEARSHOE
1	1	D3535-39	WEARSHOE
1	1	D3536-15	GASKET
1	1	D3536-23	GASKET
1	1	D3536-35	GASKET
1	1	D3536-39	GASKET
9	9	D3537-1	WEARPAD
1	1	D3537-3	WEARPAD
78	78	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
80	80	AN3C4A	BOLT
1	1	AN4C5A	BOLT
1	1	AN960C416	WASHER
80	80	AN960C10L	WASHER
2	2	CCR264SS3-3	RIVET
2	2	CR3212-4-03	RIVET
2	2	NAS1515H3L	WASHER

GENERAL NOTES:

1. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
2. DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
3. ALL HOLES DRILLED ON CENTERLINES.
4. BOND D3282-041 FLOAT WEB INTO D3274-1/-3 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
5. WELDING TO BE DONE PER DART QSI 004.
6. FINISH: - ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1
- POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
7. DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3274-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX -241/-291.
8. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

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WITHOUT NOTICE
WORK ORDER
NO 146791

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Date: Wednesday, 22/04/2009 5:53:04 AM
 User: Linda Lacelle

Employee Time Report

Date Range: From : 21/04/2009 To: 22/04/2009

From : To :

Employee: GOLD01		Golden, Brigitte						
Busin. Date	Date	In	Pay In	Out	Pay Out	Lunch Hrs	Pay Hrs	Total Time (hrs)
21/04/2009		10:29	10:30	16:25	16:25	0.50	5.42	5.94
Total:							5.42	5.94
Employee: GREG01		Gregory, Marc						
Busin. Date	Date	In	Pay In	Out	Pay Out	Lunch Hrs	Pay Hrs	Total Time (hrs)
21/04/2009		10:08	10:09	16:21	16:21	0.50	5.70	6.22
Total:							5.70	6.22
Employee: HUM001		Hum, Peter						
Busin. Date	Date	In	Pay In	Out	Pay Out	Lunch Hrs	Pay Hrs	Total Time (hrs)
21/04/2009		10:49	10:50	16:31	16:31	0.50	5.18	5.70
Total:							5.18	5.70
Employee: LABR01		Labrie, Carole						
Busin. Date	Date	In	Pay In	Out	Pay Out	Lunch Hrs	Pay Hrs	Total Time (hrs)
21/04/2009				16:37	16:37	0.00		OUT ONLY
Total:							0.00	0.00
Employee: LACE01		Lacelle, Linda						
Busin. Date	Date	In	Pay In	Out	Pay Out	Lunch Hrs	Pay Hrs	Total Time (hrs)
21/04/2009		10:26	10:27	15:46	15:46	0.50	4.82	5.32
22/04/2009		05:50	05:51			0.00		IN ONLY
Total:							4.82	5.32
Employee: LACR01		Lacroix, Francis						
Busin. Date	Date	In	Pay In	Out	Pay Out	Lunch Hrs	Pay Hrs	Total Time (hrs)
21/04/2009		11:42	11:43	16:30	16:30	0.50	4.28	4.80
Total:							4.28	4.80
Employee: LAFO01		Lafontaine, France						
Busin. Date	Date	In	Pay In	Out	Pay Out	Lunch Hrs	Pay Hrs	Total Time (hrs)
21/04/2009		10:21	10:22	15:43	15:43	0.50	4.85	5.37
Total:							4.85	5.37
Employee: LAMA01		Lamarche, Mathieu						
Busin. Date	Date	In	Pay In	Out	Pay Out	Lunch Hrs	Pay Hrs	Total Time (hrs)
21/04/2009		10:29	10:30	18:02	18:02	0.50	7.03	7.55
22/04/2009		05:29	05:30			0.00		IN ONLY
Total:							7.03	7.55
Employee: LARO01		Larocque, Eric						
Busin. Date	Date	In	Pay In	Out	Pay Out	Lunch Hrs	Pay Hrs	Total Time (hrs)
21/04/2009		10:46	10:47	17:54	17:54	0.50	6.62	7.14
Total:							6.62	7.14
Employee: LAUG01		Laughren, Gary						
Busin. Date	Date	In	Pay In	Out	Pay Out	Lunch Hrs	Pay Hrs	Total Time (hrs)
21/04/2009		12:00	12:00	16:26	16:26	0.50	3.93	4.45
Total:							3.93	4.45
Employee: LAVI01		Laviolette, Carl						
Busin. Date	Date	In	Pay In	Out	Pay Out	Lunch Hrs	Pay Hrs	Total Time (hrs)
21/04/2009		11:07	11:08	18:55	18:55	0.50	7.28	7.80

Date: Wednesday, 22/04/2009 7:17:26 AM

User: Linda Lacelle

JOB HISTORY : DETAIL

Job Number	: 35202A	Customer	: Dart Helicopters Services
Estimate Number	: 10309	DWG Name	: FLOAT SKIDTUBE ASSEMBLY
Purchase Order #	:	Part Number	: D206642541
Complete Date	: 02/11/2007 9:50:16	DWG Number	: D3274 REV D
Rev.	: D		

DUE DATE	ORDERED	DELIVERED
10/11/2007	1	1

2.0 D26001190-Extrusion Round 3" 206	INVENTORY ITEM
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DATE	EMPLOYEE	TYPE	Qty		COST	
22/10/2007	PAQU03: Paquette, Dan	D26001190	1.000		\$49.38	Lot # 31032 Qty. 1
Subtotal:	QTD:	0 CTD:	1		\$49.38	

3.0 SKIDTUBES 1	Internal Operation
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DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach. Cost
22/10/2007	PAQU03: Paquette, Dan	Run	1.000	0.71	\$11.69	0.71	14.73
Subtotal:	QTD:	1 CTD:	0	0.71	\$26.42		

4.0 HAND FINISHING1	Internal Operation
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DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach. Cost
22/10/2007	PAQU03: Paquette, Dan	Run	1.000	0.56	\$9.22	0.56	17.89
Subtotal:	QTD:	1 CTD:	0	0.56	\$27.11		

7.0 D3282041-Float Web (206L/407)	INVENTORY ITEM
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DATE	EMPLOYEE	TYPE	Qty		COST	
23/10/2007	MAHE01: Maheu, Andrew	D3282041	1.000		\$314.74	Lot # 34794 Qty. 1
Subtotal:	QTD:	0 CTD:	1		\$314.74	

8.0 SKIDTUBES 1	Internal Operation
------------------------	---------------------------

DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach. Cost
23/10/2007	PAQU03: Paquette, Dan	Run	1.000	0.19	\$3.13	0.19	3.94
23/10/2007	MAHE01: Maheu, Andrew	Run	1.000	0.29	\$4.77	0.29	6.01
Subtotal:	QTD:	2 CTD:	0	0.48	\$17.85		

10.0 SKIDTUBES 1	Internal Operation
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DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach. Cost
24/10/2007	LARO01: Larocque, Eric	Run	1.000	0.60	\$9.88	0.61	12.65
24/10/2007	RAIN01: Rainey, Jamie	Run	1.000	0.61	\$10.04	0.61	12.65
24/10/2007	PAQU03: Paquette, Dan	Run	1.000	1.62	\$26.67	1.62	33.60
Subtotal:	QTD:	3 CTD:	0	2.83	\$105.49		

12.0 D32851-Cap	INVENTORY ITEM
------------------------	-----------------------

DATE	EMPLOYEE	TYPE	Qty		COST	
25/10/2007	ELLI01: Elliott, Barclay	D32851	1.000		\$2.99	Lot # 33374 Qty. 1
Subtotal:	QTD:	0 CTD:	1		\$2.99	

13.0 D2649-Cross Bolt Spacer	INVENTORY ITEM
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DATE	EMPLOYEE	TYPE	Qty		COST	
25/10/2007	ELLI01: Elliott, Barclay	D2649	12.000		\$11.85	Lot # 34612 Qty. 12
Subtotal:	QTD:	0 CTD:	12		\$11.85	

REFERENCE ONLY

Date: Wednesday, 22/04/2009 7:17:26 AM

User: Linda Lacelle

JOB HISTORY : DETAIL

Job Number	: 35202A	Customer	: Dart Helicopters Services
Estimate Number	: 10309	DWG Name	: FLOAT SKIDTUBE ASSEMBLY
Purchase Order #	:	Part Number	: D206642541
Complete Date	: 02/11/2007 9:50:16	DWG Number	: D3274 REV D
Rev.	: D		

14.0 D32751-Crossbolt Spacer INVENTORY ITEM							
DATE	EMPLOYEE	TYPE	Qty		COST		
25/10/2007	ELLI01: Elliott, Barclay	D32751	12.000		\$22.56		Lot # 33429 Qty. 5 Lot # 34619 Qty. 7
Subtotal:		QTD:	0	CTD:	12	\$22.56	

15.0 SKIDTUBES 1 Internal Operation							
DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach.Cost
24/10/2007	ELLI01: Elliott, Barclay	Run	0.000	1.40	\$23.04	1.40	29.03
25/10/2007	ELLI01: Elliott, Barclay	Run	0.000	0.62	\$10.21	0.62	12.86
25/10/2007	LEVI01: Levis, Sylvain	Run	0.000	0.00	\$0.00	2.90	60.14
25/10/2007	LEVI01: Levis, Sylvain	Run	1.000	2.90	\$47.73	0.00	0.00
25/10/2007	RAIN01: Rainey, Jamie	Run	1.000	0.92	\$15.14	0.92	19.08
Subtotal:		QTD:	2	CTD:	0	5.84	\$217.23

18.0 POWDER COATING Internal Operation							
DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach.Cost
29/10/2007	GREG01: Gregory, Marc	Run	0.000	0.80	\$10.74	0.80	20.84
29/10/2007	ROQU01: Roquebrune, Benoit	Run	1.000	0.34	\$4.68	0.67	17.87
Subtotal:		QTD:	1	CTD:	0	1.14	\$54.13

20.0 D3415041-Nut Plate INVENTORY ITEM							
DATE	EMPLOYEE	TYPE	Qty		COST		
30/10/2007	LAUG01: Laughren, Gary	D3415041	1.000		\$10.69		Lot # 33434 Qty. 1
Subtotal:		QTD:	0	CTD:	1	\$10.69	

21.0 CCR264SS33-Cherry Rivet INVENTORY ITEM							
DATE	EMPLOYEE	TYPE	Qty		COST		
30/10/2007	LAUG01: Laughren, Gary	CCR264SS33	2.000		\$0.24		Lot # 103525 Qty. 2
Subtotal:		QTD:	0	CTD:	2	\$0.24	

22.0 CR3212403-Cherry Rivet INVENTORY ITEM							
DATE	EMPLOYEE	TYPE	Qty		COST		
02/11/2007	LACE01: Lacelle, Linda	CR3212403	2.000		\$1.02		Lot # 15939 Qty. 2
Subtotal:		QTD:	2	CTD:	0	\$1.02	

23.0 ALS41032130-Insert INVENTORY ITEM							
DATE	EMPLOYEE	TYPE	Qty		COST		
02/11/2007	LACE01: Lacelle, Linda	ALS41032130	78.000		\$9.65		Lot # 105729 Qty. 78
Subtotal:		QTD:	78	CTD:	0	\$9.65	

26.0 AN3C4A-BOLT INVENTORY ITEM							
DATE	EMPLOYEE	TYPE	Qty		COST		
30/10/2007	LAUG01: Laughren, Gary	AN3C4A	80.000		\$24.86		Lot # 105810 Qty. 80
Subtotal:		QTD:	0	CTD:	80	\$24.86	

Date: Wednesday, 22/04/2009 7:17:26 AM

User: Linda Lacelle

JOB HISTORY : DETAIL

Job Number	: 35202A	Customer	: Dart Helicopters Services
Estimate Number	: 10309	DWG Name	: FLOAT SKIDTUBE ASSEMBLY
Purchase Order #	:	Part Number	: D206642541
Complete Date	: 02/11/2007 9:50:16	DWG Number	: D3274 REV D
Rev.	: D		

27.0 D353515-Wearshoe INVENTORY ITEM						
DATE	EMPLOYEE	TYPE	Qty		COST	
30/10/2007	LAUG01: Laughren, Gary	D353515	1.000		\$17.10	Lot # 34624 Qty. 1
Subtotal:		QTD:	0	CTD:	1	\$17.10

28.0 D353523-Wearshoe INVENTORY ITEM						
DATE	EMPLOYEE	TYPE	Qty		COST	
30/10/2007	LAUG01: Laughren, Gary	D353523	1.000		\$58.82	Lot # 32735 Qty. 1
Subtotal:		QTD:	0	CTD:	1	\$58.82

29.0 D353535-Wearshoe INVENTORY ITEM						
DATE	EMPLOYEE	TYPE	Qty		COST	
30/10/2007	LAUG01: Laughren, Gary	D353535	1.000		\$11.47	Lot # 33371 Qty. 1
Subtotal:		QTD:	0	CTD:	1	\$11.47

30.0 D353539-Wearshoe INVENTORY ITEM						
DATE	EMPLOYEE	TYPE	Qty		COST	
30/10/2007	LAUG01: Laughren, Gary	D353539	1.000		\$19.78	Lot # 33440 Qty. 1
Subtotal:		QTD:	0	CTD:	1	\$19.78

31.0 D353615-Gasket INVENTORY ITEM						
DATE	EMPLOYEE	TYPE	Qty		COST	
30/10/2007	LAUG01: Laughren, Gary	D353615	1.000		\$2.60	Lot # 33964 Qty. 1
Subtotal:		QTD:	0	CTD:	1	\$2.60

32.0 D353623-Gasket INVENTORY ITEM						
DATE	EMPLOYEE	TYPE	Qty		COST	
30/10/2007	LAUG01: Laughren, Gary	D353623	1.000		\$2.64	Lot # 33965 Qty. 1
Subtotal:		QTD:	0	CTD:	1	\$2.64

33.0 D353635-Gasket INVENTORY ITEM						
DATE	EMPLOYEE	TYPE	Qty		COST	
30/10/2007	LAUG01: Laughren, Gary	D353635	1.000		\$1.75	Lot # 34828 Qty. 1
Subtotal:		QTD:	0	CTD:	1	\$1.75

34.0 D353639-Gasket INVENTORY ITEM						
DATE	EMPLOYEE	TYPE	Qty		COST	
30/10/2007	LAUG01: Laughren, Gary	D353639	1.000		\$2.23	Lot # 33966 Qty. 1
Subtotal:		QTD:	0	CTD:	1	\$2.23

35.0 D35371-Wearpad INVENTORY ITEM						
DATE	EMPLOYEE	TYPE	Qty		COST	
30/10/2007	LAUG01: Laughren, Gary	D35371	9.000		\$220.64	Lot # 34282 Qty. 9
Subtotal:		QTD:	0	CTD:	9	\$220.64

Date: Wednesday, 22/04/2009 7:17:27 AM

User: Linda Lacelle

JOB HISTORY : DETAIL

Job Number : 35202A		Customer : Dart Helicopters Services	
Estimate Number : 10309		DWG Name : FLOAT SKIDTUBE ASSEMBLY	
Purchase Order # :		Part Number : D206642541	
Complete Date : 02/11/2007 9:50:16		DWG Number : D3274 REV D Rev. : D	

36.0 D35373-Wearpad INVENTORY ITEM						
DATE	EMPLOYEE	TYPE	Qty		COST	
30/10/2007	LAUG01: Laughren, Gary	D35373	1.000		\$31.94	Lot # 33285 Qty. 1
Subtotal:		QTD:	0	CTD:	1	\$31.94

37.0 AN960C10L-washer INVENTORY ITEM						
DATE	EMPLOYEE	TYPE	Qty		COST	
30/10/2007	LAUG01: Laughren, Gary	AN960C10L	80.000		\$2.78	Lot # 105143 Qty. 80
Subtotal:		QTD:	0	CTD:	80	\$2.78

38.0 NAS1515H3L-WASHER INVENTORY ITEM						
DATE	EMPLOYEE	TYPE	Qty		COST	
30/10/2007	LAUG01: Laughren, Gary	NAS1515H3L	2.000		\$0.18	Lot # 105116 Qty. 2
Subtotal:		QTD:	0	CTD:	2	\$0.18

39.0 D34131-Ring INVENTORY ITEM						
DATE	EMPLOYEE	TYPE	Qty		COST	
30/10/2007	LAUG01: Laughren, Gary	D34131	1.000		\$10.78	Lot # 34753 Qty. 1
Subtotal:		QTD:	0	CTD:	1	\$10.78

40.0 AN4C5A-BOLT INVENTORY ITEM						
DATE	EMPLOYEE	TYPE	Qty		COST	
30/10/2007	LAUG01: Laughren, Gary	AN4C5A	1.000		\$0.70	Lot # 18918 Qty. 1
Subtotal:		QTD:	0	CTD:	1	\$0.70

41.0 AN960C416-washer INVENTORY ITEM						
DATE	EMPLOYEE	TYPE	Qty		COST	
30/10/2007	LAUG01: Laughren, Gary	AN960C416	1.000		\$0.03	Lot # 100993 Qty. 1
Subtotal:		QTD:	0	CTD:	1	\$0.03

42.0 D2646-Aft Cap INVENTORY ITEM						
DATE	EMPLOYEE	TYPE	Qty		COST	
30/10/2007	LAUG01: Laughren, Gary	D2646	1.000		\$12.89	Lot # 33289 Qty. 1
Subtotal:		QTD:	0	CTD:	1	\$12.89

43.0 HAND FINISHING1 Internal Operation							
DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach. Cost
30/10/2007	LAUG01: Laughren, Gary	Run	1.000	4.41	\$59.18	4.42	115.08
Subtotal:		QTD:	1	CTD:	0	4.41	\$174.26

		TIME	COST
Machine Time:		16.32	\$376.37
Labor:		15.97	\$246.12
Sub-contract (external Op.):			\$0.00
INVENTORY ITEM:			\$844.31
SUB-COMPONENT (SUB-JOB):			\$0.00
Total:			\$1466.80
COST PER UNIT:		\$1466.80	

DART

TRANSPORT CANADA APPROVAL # 09-89

TEL: 613-632-3336
FAX: 613-632-4443

P N	D206-642-512	CHG	CHG003
DESC	Float Skidtube RH	STC	SH98-4
LOT	B35202	STC	SA00475SE
MODEL	206L/L1/L3/L4/407	STC	

US PATENT # 5,238,373

CANADA PATENT # 2,141,411

MADE IN CANADA